

Date: Tuesday, 4/18/2006 9:58:37 AM  
 User: Kim Johnston

## Process Sheet

SS *split*  
*6/6/12*

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GAS SPRING		
Job Number	: 26646					
Estimate Number	: 10336					
P.O. Number	: N/A			Part Number	: D2807	
This Issue	: 4/18/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2807 REV C	
First Issue	: N/A			Project Number	: N/A	
Previous Run	: 25247			Drawing Revision	: C	
Written By	: <i>[Signature]</i> <i>(Comments Below)</i>			Material	: N/A	
Checked & Approved By	: <i>[Signature]</i> <i>06.04.18</i>			Due Date	: 5/5/2006	
Comment	: Est: D 05.06.21 Removed painting; Changed supplier KJ/JLM			Qty:	50	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		<b>Comment:</b> PURCHASING Issue P/O: <i>1035</i> Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required	<i>C 206104119 (50)</i>
2.0	SXF6S6050080S6L115N	GAS SPRING	
		<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) SUPPORT PROP	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached	<i>106/6/12 (50)</i>
4.0	QC6	DIMENSIONAL CHECK	 <i>J 26/6/12 (50)</i>
		<b>Comment:</b> DIMENSIONAL CHECK	
5.0	D28073	Lug	 <i>J 26/6/12 (50)</i>
		<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s) Pick: 2 D2807-3 Lug Batch: <i>(526757) 2 B27152 (46) B26757 (26) B47 (4) B26</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/06/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 26646

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.

SA

06/06/13

(38)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

06/06/13

(38)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST381

SL 06/06/13

(38)

9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

9 06/06/14

(38)

Job Completion



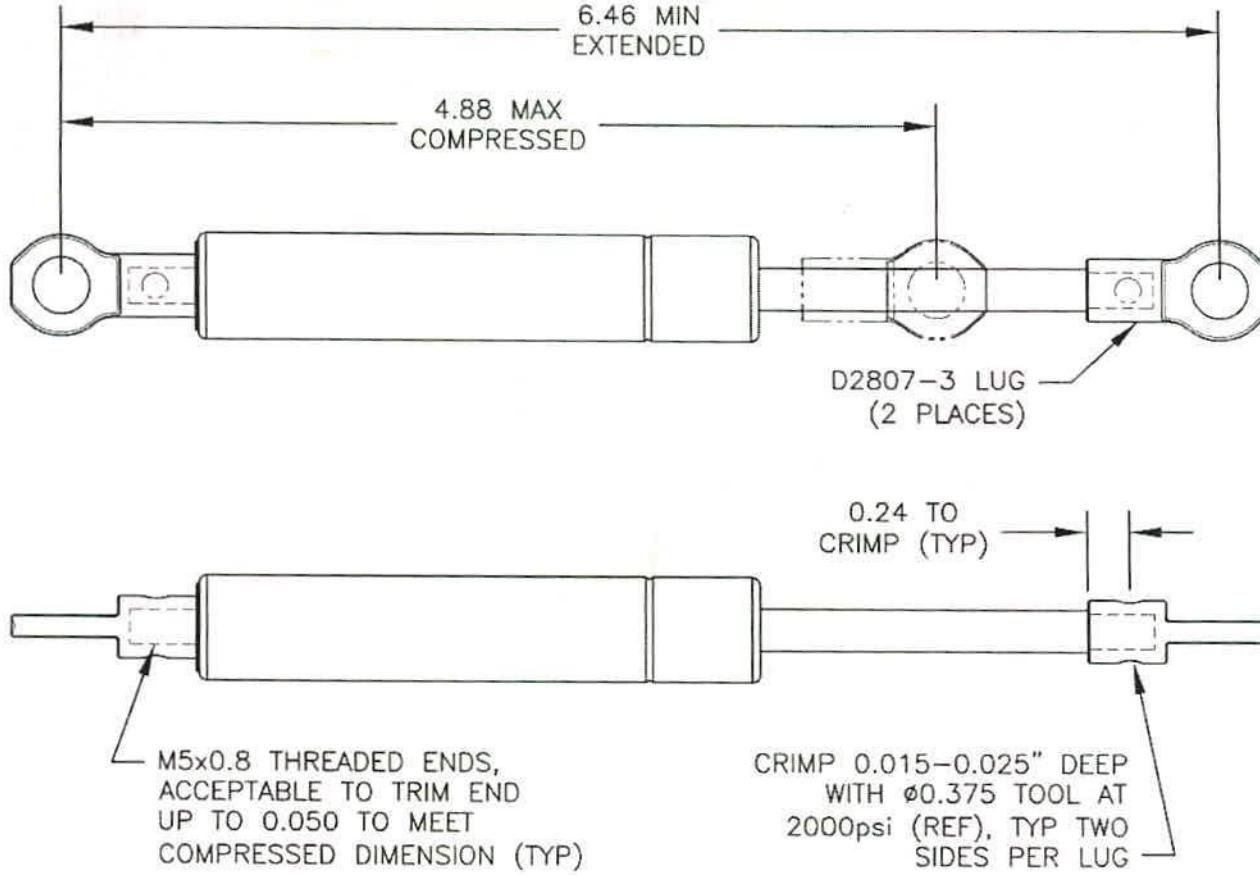
✓ 06-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



### D2807 GAS SPRING

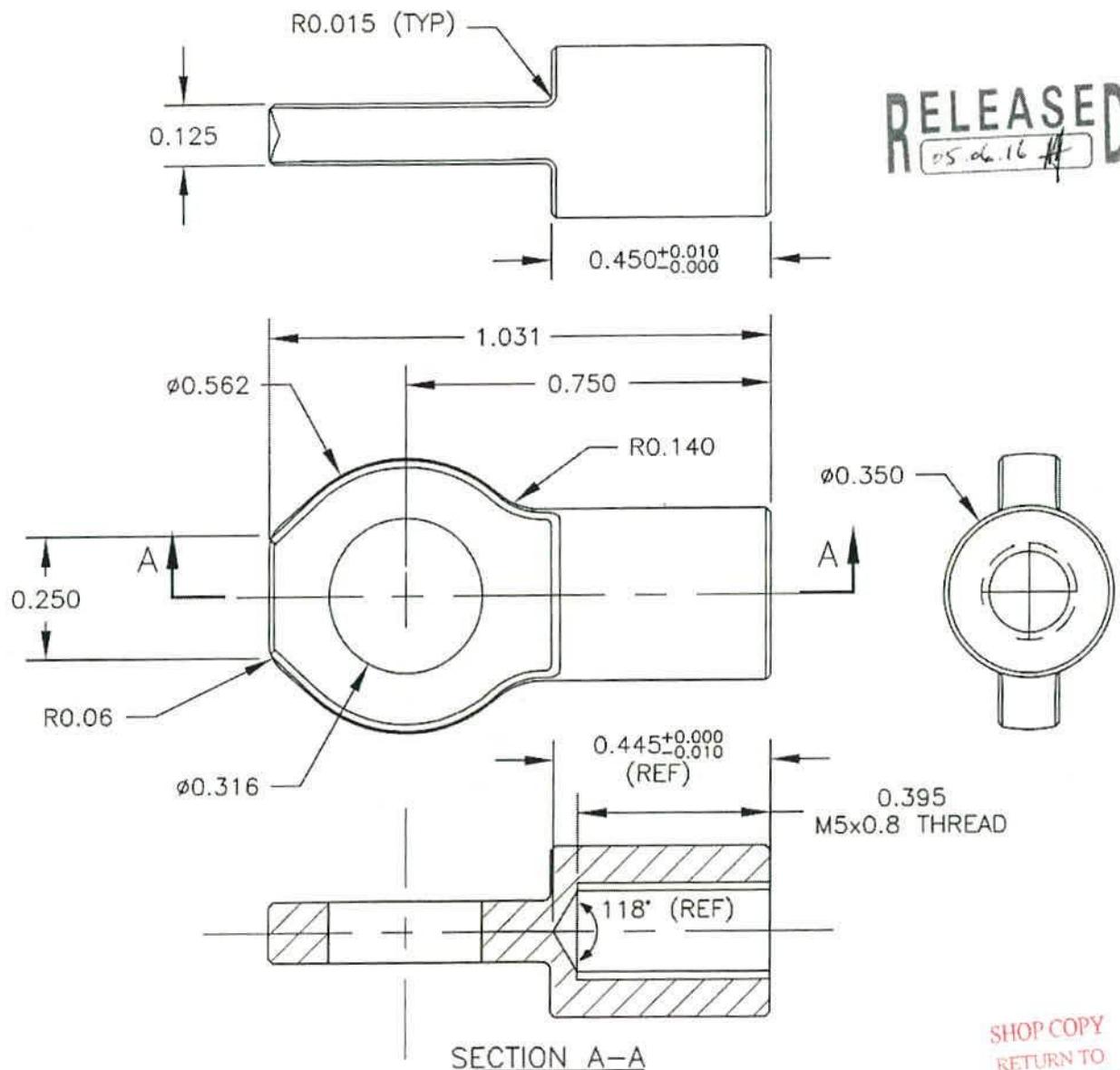
- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS
- 2) SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)  
NO 26646  
NOT ORDER  
ENGINEERING  
IN CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
R  
2000-06-16

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
05.05.25	D2807	SHEET 1 OF 2
A	00.11.03	SCALE 1:1
B	05.03.16	TITLE GAS SPRING
C	05.05.25	ADD FINISH
		CHANGE SPRING TO SS, ADD -3 LUG

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2807
DATE 05.05.25	TITLE GAS SPRING	REV. C SHEET 2 OF 2 SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26646

**INVOICE TO**

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ONTARIO  
K6A 1K7  
CANADA

DART AEROSPACE LTD  
SHIP WITH AE: 57561 VIA  
FEDEX P-1 OVERNIGHT SVCE  
ACCOUNT NO: 15179324-0

A/C No

A/C No.
20111

46

CUSTOMER REF. N  
00001035

V.A.T. REGISTRATION No. GB 738 8577 71

W ORDER  
NUMBER

Cam 001

**Irvin Motion Control Limited.**  
Main Tel: +44 (0)116 274 3600  
Sales Tel: +44 (0)116 274 3622  
Accounts Tel: +44 (0)116 274 3623

15 New Star Road, Leicester, LE4 9JD, UK  
Main Fax: +44 (0)116 274 3620  
E-mail - [info.amcl@arvinmeritor.com](mailto:info.amcl@arvinmeritor.com)  
Website: [www.camloc.com](http://www.camloc.com)

FED EX  
8490 2198 6376

**YOUR ORDER WAS PACKED BY**  
Certified that the whole of the supplies detailed herein  
have been inspected and tested and unless otherwise stated  
conform in all respects with the contract/purchase order  
requirements.

SIGNED \_\_\_\_\_  
POSITION \_\_\_\_\_

